

Date: Monday, 22/10/2007 2:17:15 PM  
User: Linda Lacelle

## Process Sheet

split (b)

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM	
Job Number	: 35296-13			Part Number	: D3560042	
Estimate Number	: 12882			Drawing Number	: D3560 UNDER REVIEW	
P.O. Number	:			Project Number	: N/A	
This Issue	: 22/10/2007 S.O. No. :			Drawing Revision	: C	
Prsht Rev.	: NC			Material	:	
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 29/10/2007 Qty: 2	
Previous Run	: 35030				Um: Each	
Written By	:				2	
Checked & Approved By	:				5	
Comment	Est Rev:A	New Issue	07.05.24 EC		14	
	est rev B	ECN 987	07.10.09 EC			
verified by: DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
Comment: Qty.: 1.4648 f(s)/Unit Total : 20.5065 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: M106182		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks 16.750" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		
1- Mill as per Folio FA694 Rev: <u>11</u> & Dwg D3560 Rev: <u>C</u> 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		



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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D35921	PLATE
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s) PLATE		B 35331 SP 08.08.15 (2x)
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld assembly as per dwg D3560		
STEP:		
1- clean material (buff bracket and bottom of arm with blue pad ) SP		
2- set up bracket and arm on jig SP		
3- preheat bracket and arm with torch SP		
4- clean before welding with brush SP		
5- set up machine to 135 amps SP		
6- weld across bottom and top ends SP		
7- reheat with torch ( ) SP		
8- on one side weld from bottom to top half way SP		
9- same for other side (half way) SP		
10- from half way point weld the rest of the first side (ease off pedal near end) SP		
11- same for remaining side (ease off pedal near end) SP		
SP 08.08.15 (2x)		
8.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		
9.0	QC9	VISUAL WELDING INSPECTION
		
Comment: VISUAL WELDING INSPECTION		
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1		
SP 08.08.15 (2x)		



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Drawing Name: ARM

Job Number: 35296

Part Number: D3560042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11 08-08-15 2

12.0 D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer

B 37113

38 08/08/18 ②

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

38 08/08/18 ②

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

INSPECT WORK TO CURRENT STEP

11 08-08-18 ②

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 211A

11 08-08-28

16.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

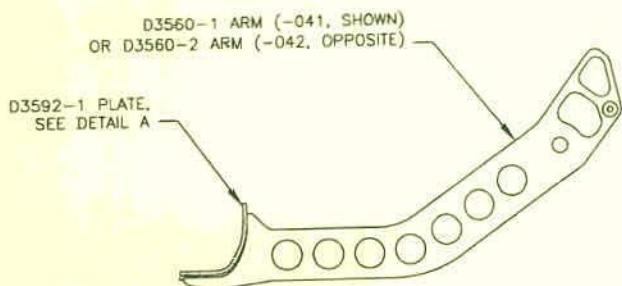
11 08-08-29

Job Completion

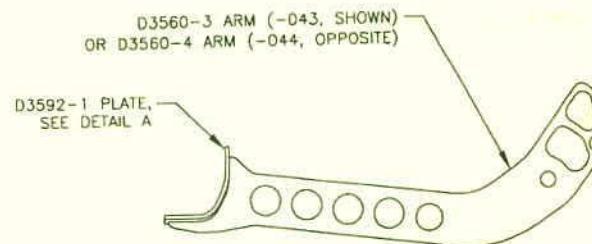


MF 08-08-28

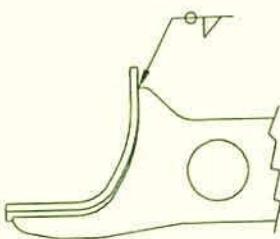
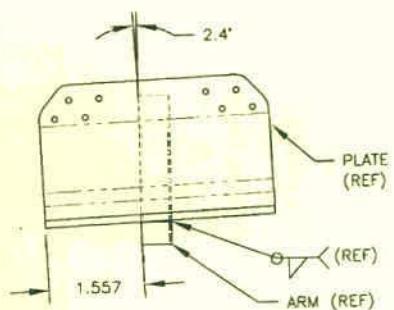




D3560-041 ARM WELDMENT (SHOWN)  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN)  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.19  
**UNDER REVIEW**  
07.10.22 DC

*WJ 3560*  
*07.06.19*

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DESIGN	07.06.19	DRAWN BY	99	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	99	APPROVED	99	DRAWING NO.	07.06.19
				D3560	ARM WELDMENT
DATE	07.06.19	TITLE		SCALE	1:1

REV. C  
SHEET 1 OF 3

